

Work Order ID 91220

October-03-12 2:39:11 PM

91220

Page 1

Item ID: D2661-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 09/01/2013 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-10-03

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>E</u>								
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

FK 12/12/04
BK 12.12.01
FK 12/12/04

30 0
30 0

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

October-03-12 2:39:11 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

30

30

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 91220

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Page 3

Item ID: D2661-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 09/01/2013 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

30 X 4

12/12/12

M123383

3200 F

9=30

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

30 12-12-12



170

Identify as per dwg & Stock Location: ST

0.00

170

Packaging

Memo

0.00

Packaging

432

6/4/12 (30)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Work Order ID 91220

October-03-12 2:39:11 PM

91220

Page 4

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 09/01/2013 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

ML5 12-12-12

ML5 12-12-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
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FAULT CATEGORY																											
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Picklist Print

October-03-12 2:39:14 PM

Page 1

Work Order ID: 91220

Parent Item: D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

91220

D2661-2

Start Date: 03/10/2012

Required Date: 09/01/2013

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	24.0000	1	30			
D6101-003									**				
Saddle Billet, 7075													

Location

Loc Qty

Loc Code

MAT040

26

73775

2

73780

7

78599

10

80765

0

MAT042

-3

87498

4

MAT044

1

73769

1

91239

30

FK 12/11/29.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
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Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DART AEROSPACE LTD		Work Order:	91220
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.613	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.118	.118	.118	.118
H	0.210	0.230		.223	.223	.223	.223	.223
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.323	1.323	1.323	1.323	1.323
L	0.178	0.198		.180	.180	.180	.180	.180
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.137	1.137	1.137	1.137
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.126	.126	.126	.126	.126
Q	0.240	0.260		.249	.249	.249	.249	.249
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.122	.122	.122	.122	.122
T	1.565	1.585		1.577	1.577	1.577	1.577	1.577
U	0.540	0.560		.560	.560	.560	.560	.560
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.500	.500	.500	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.998	.998	.998	.998	.998
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.113	.113	.113	.113	.113
Accept/Reject								

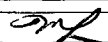
Measured by: FKH. 136	Date: 12/11/30
Audited by: [Signature]	Date: 12/12/09
Prototype Approval:	Date:



Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	91220
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				4 6	2 7	2 8	4 9	5 W
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.259	.259	.259	.259	.259
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.121	.121	.121	.121	.121
H	0.210	0.230		.223	.223	.223	.223	.223
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.494	2.494	2.494	2.494	2.494
K	1.313	1.343		1.327	1.327	1.327	1.327	1.327
L	0.178	0.198		.187	.187	.187	.187	.187
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.140	1.140	1.140	1.140	1.140
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.130	.130	.130	.130	.130
Q	0.240	0.260		.246	.246	.246	.246	.246
R	0.677	0.697		.692	.692	.692	.692	.692
S	0.100	0.140		.124	.124	.124	.124	.124
T	1.565	1.585		1.574	1.574	1.574	1.574	1.574
U	0.540	0.560		.551	.551	.551	.551	.551
V	0.912	0.932		.924	.924	.924	.924	.924
W	0.787	0.807		.800	.800	.800	.800	.800
X	5.990	6.010		6.002	6.002	6.002	6.002	6.002
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.501	.501	.501	.501	.501
AA	0.312	0.319		.315	.315	.315	.315	.315
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.501	.501	.501	.501	.501
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
Accept/Reject								

Measured by: BG	Date: 12.02.01
Audited by: 	Date: 12/12/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ 	

DART AEROSPACE LTD			Work Order: 91220	
Description: 206 Saddle, Outboard, Right side			Part Number:	D2661-2
Inspection Dwg: D2661	Rev: E	DSK:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1 1	1 2	1 3	1 4	1 5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.259	.259	.259	.259	.259
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.118	.118	.118	.118	.118
H	0.210	0.230		.222	.222	.222	.222	.222
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.494	2.494	2.494	2.494	2.494
K	1.313	1.343		1.322	1.322	1.322	1.322	1.322
L	0.178	0.198		.187	.187	.187	.187	.187
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.131	1.132	1.132	1.132	1.132
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.130	.130	.130	.130	.130
Q	0.240	0.260		.248	.248	.248	.248	.248
R	0.677	0.697		.692	.692	.692	.692	.692
S	0.100	0.140		.130	.130	.130	.130	.130
T	1.565	1.585		1.570	1.570	1.570	1.570	1.570
U	0.540	0.560		.551	.551	.551	.551	.551
V	0.912	0.932		.925	.925	.925	.925	.925
W	0.787	0.807		.800	.800	.800	.800	.800
X	5.990	6.010		6.002	6.002	6.002	6.002	6.002
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.501	.501	.501	.501	.501
AA	0.312	0.319		.311	.311	.311	.311	.311
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.503	.503	.503	.503
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
Accept/Reject								

Measured by: SC	Date: 12.12.02
Audited by: <i>SC</i>	Date: 12/12/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>AA</i>

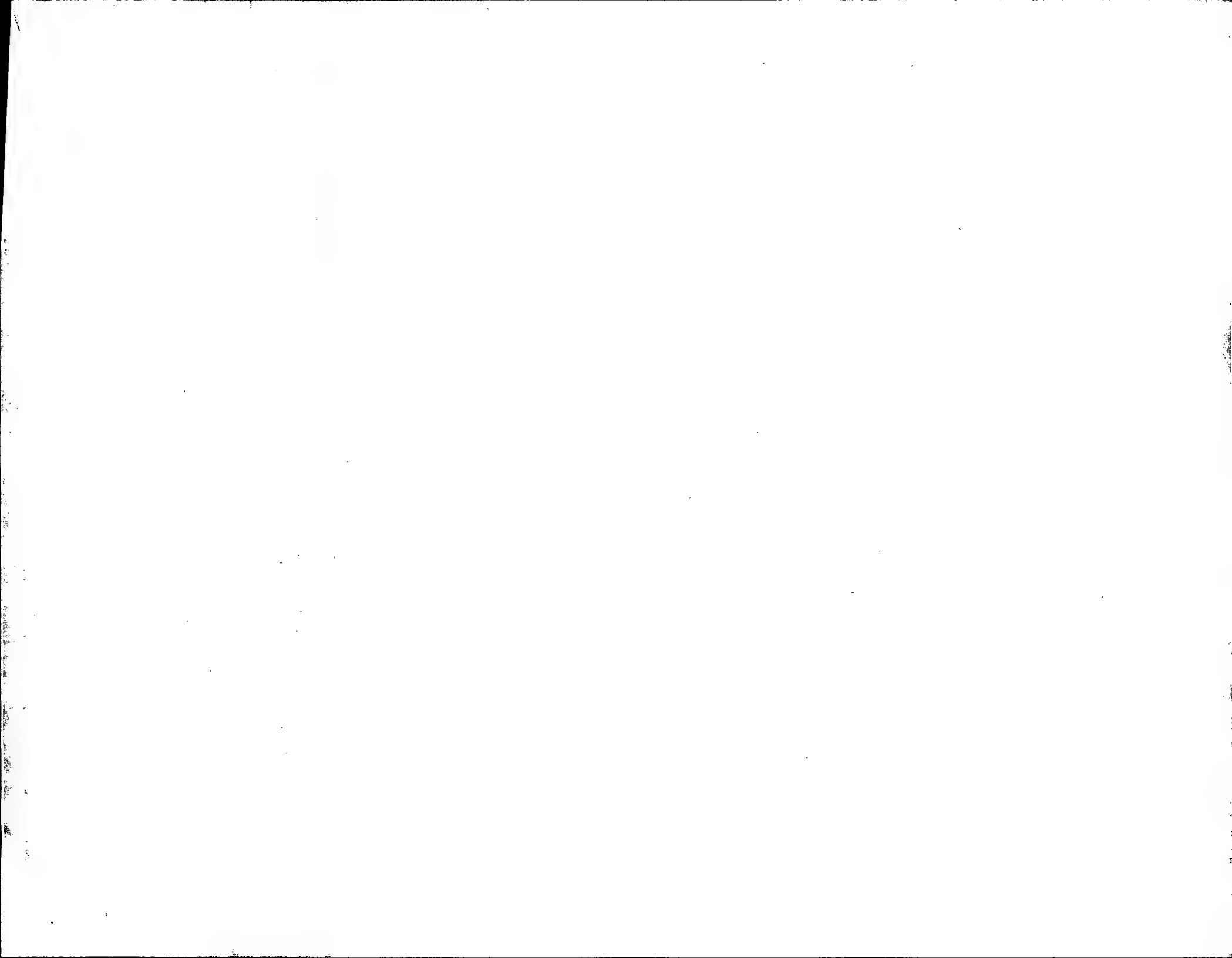
DART AEROSPACE LTD		Work Order: 01220	
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2	
Inspection Dwg: D2661		Rev: E	DSK: Rev:
		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 ¹⁶	2 ¹⁷	3 ¹⁸	4 ¹⁹	5 ²⁰
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.363	1.363	1.363	1.363	1.363
G	0.100	0.140		.118	.118	.118	.118	.118
H	0.210	0.230		.220	.220	.220	.220	.220
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.494	2.494	2.494	2.494	2.494
K	1.313	1.343		1.322	1.322	1.322	1.322	1.322
L	0.178	0.198		.187	.187	.187	.187	.187
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.130	1.130	1.130	1.130	1.130
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.132	.132	.132	.132	.132
Q	0.240	0.260		.248	.248	.248	.248	.248
R	0.677	0.697		.694	.694	.694	.694	.694
S	0.100	0.140		.126	.126	.126	.126	.126
T	1.565	1.585		1.570	1.570	1.570	1.570	1.570
U	0.540	0.560		.552	.552	.552	.552	.552
V	0.912	0.932		.928	.928	.928	.928	.928
W	0.787	0.807		.800	.800	.800	.800	.800
X	5.990	6.010		6.002	6.002	6.002	6.002	6.002
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.502	.502	.502	.502	.502
AA	0.312	0.319		.313	.313	.313	.313	.313
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.502	.502	.502	.502	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
Accept/Reject								

Measured by: <u>SL</u>	Date: <u>12.12.02</u>
Audited by: <u>SL</u>	Date: <u>12/12/04</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<u>AA</u>



DART AEROSPACE LTD		Work Order:	91220
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661	Rev: E	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
				21	22	23	24	25
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.118	.118	.118	.118	.118
H	0.210	0.230		.220	.220	.220	.220	.220
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.494	2.494	2.494	2.494	2.494
K	1.313	1.343		1.324	1.324	1.324	1.324	1.324
L	0.178	0.198		.187	.187	.187	.187	.187
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.135	1.135	1.135	1.135
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.132	.132	.132	.132	.132
Q	0.240	0.260		.250	.250	.250	.250	.250
R	0.677	0.697		.690	.690	.690	.690	.690
S	0.100	0.140		.127	.127	.127	.127	.127
T	1.565	1.585		1.568	1.568	1.568	1.568	1.568
U	0.540	0.560		.552	.552	.552	.552	.552
V	0.912	0.932		.928	.928	.928	.928	.928
W	0.787	0.807		.800	.800	.800	.800	.800
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.502	.502	.502	.502	.502
AA	0.312	0.319		.315	.315	.315	.315	.315
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.502	.502	.502	.502	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.113	.113	.113	.113	.113
Accept/Reject								

Measured by: B6	Date: 12.12.03
Audited by: <i>am</i>	Date: 12/12/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD		Work Order:	91220
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.118	.118	.118	.118	.118
H	0.210	0.230		.222	.222	.222	.222	.222
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.494	2.494	2.494	2.494	2.494
K	1.313	1.343		1.327	1.327	1.327	1.327	1.327
L	0.178	0.198		.187	.187	.187	.187	.187
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.131	1.131	1.131	1.131	1.131
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.130	.130	.130	.130	.130
Q	0.240	0.260		.248	.248	.248	.248	.248
R	0.677	0.697		.693	.693	.693	.693	.693
S	0.100	0.140		.125	.125	.125	.125	.125
T	1.565	1.585		1.571	1.571	1.571	1.571	1.571
U	0.540	0.560		.552	.552	.552	.552	.552
V	0.912	0.932		.927	.927	.927	.927	.927
W	0.787	0.807		.802	.802	.802	.802	.802
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.502	.502	.502	.502	.502
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.502	.502	.502	.502	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
Accept/Reject								

Measured by: BG / FK	Date: 12.12.05
Audited by: [Signature]	Date: 12/12/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	91220
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621						
B	0.256	0.263						
C	0.315	0.322						
D	2.495	2.505						
E	1.674	1.684						
F	1.357	1.367						
G	0.100	0.140						
H	0.210	0.230						
I	0.615	0.685						
J	2.470	2.510						
K	1.313	1.343						
L	0.178	0.198						
M	0.470	0.530						
N	1.125	1.145						
O	0.100	0.180						
P	0.100	0.140						
Q	0.240	0.260						
R	0.677	0.697						
S	0.100	0.140						
T	1.565	1.585						
U	0.540	0.560						
V	0.912	0.932						
W	0.787	0.807						
X	5.990	6.010						
Y	4.995	5.005						
Z	0.490	0.510						
AA	0.312	0.319						
AB	0.990	1.010						
AC	1.245	1.255						
AD	0.490	0.510						
AE	3.745	3.755						
AF	0.235	0.240						
AG	0.510	0.515						
AH	0.100	0.120						
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD		Work Order:	91220
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621						
B	0.256	0.263						
C	0.315	0.322						
D	2.495	2.505						
E	1.674	1.684						
F	1.357	1.367						
G	0.100	0.140						
H	0.210	0.230						
I	0.615	0.685						
J	2.470	2.510						
K	1.313	1.343						
L	0.178	0.198						
M	0.470	0.530						
N	1.125	1.145						
O	0.100	0.180						
P	0.100	0.140						
Q	0.240	0.260						
R	0.677	0.697						
S	0.100	0.140						
T	1.565	1.585						
U	0.540	0.560						
V	0.912	0.932						
W	0.787	0.807						
X	5.990	6.010						
Y	4.995	5.005						
Z	0.490	0.510						
AA	0.312	0.319						
AB	0.990	1.010						
AC	1.245	1.255						
AD	0.490	0.510						
AE	3.745	3.755						
AF	0.235	0.240						
AG	0.510	0.515						
AH	0.100	0.120						
Accept/Reject								

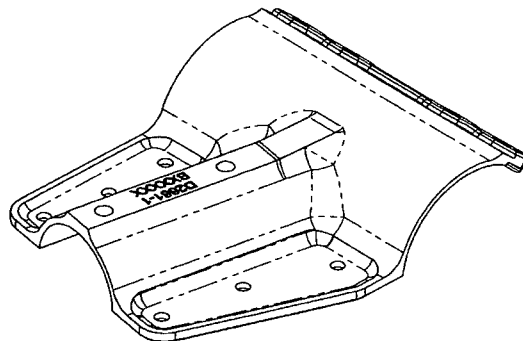
Measured by:	Date:
Audited by:	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

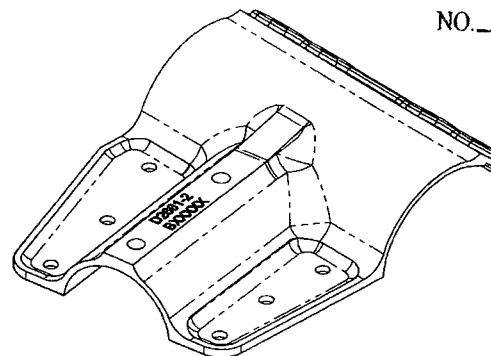
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER

NO. 91220 MLO

12-10-03



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2, B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.
D2661

REV. E

SHEET 1 OF 5

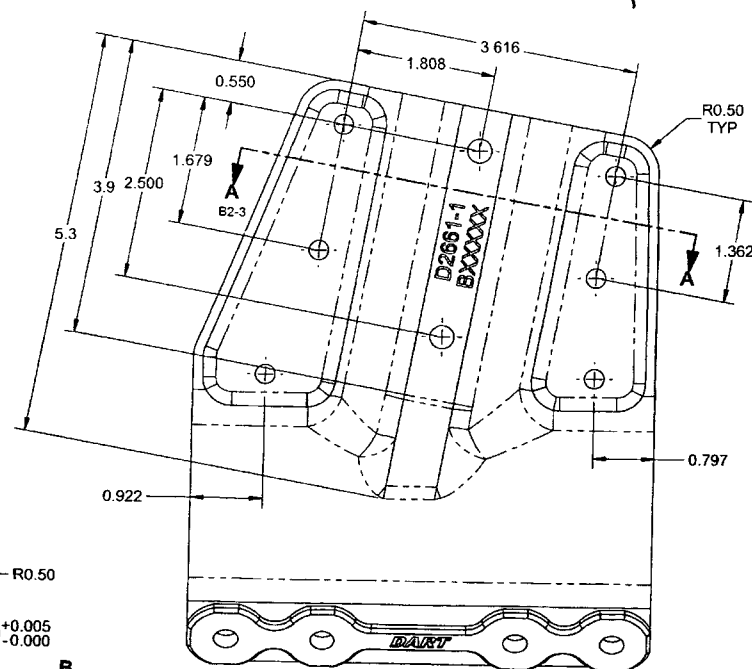
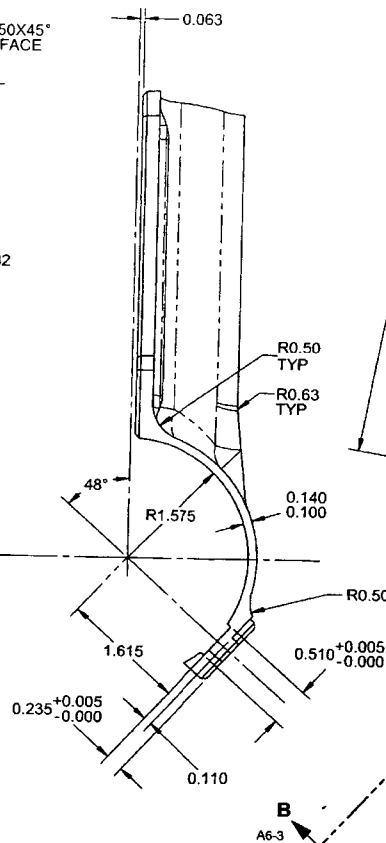
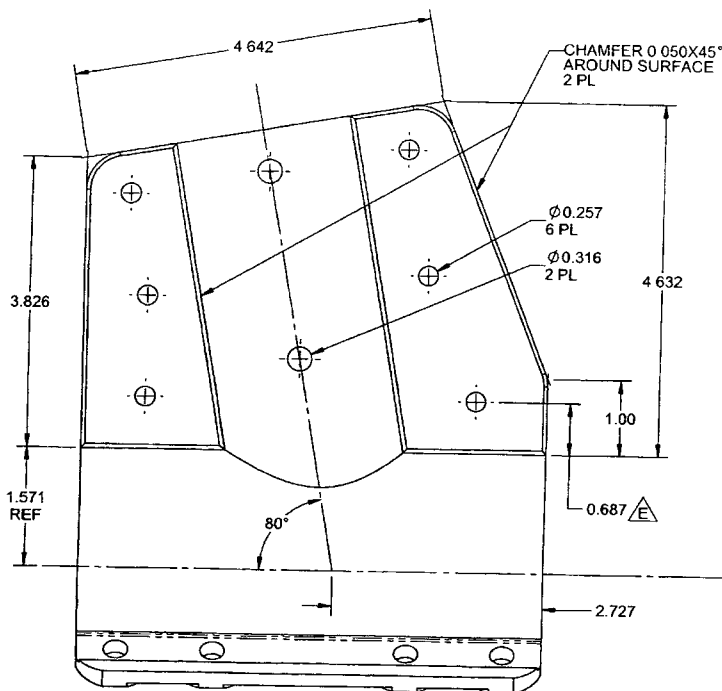
TITLE

SADDLE, OUTSIDE

SCALE
NTS

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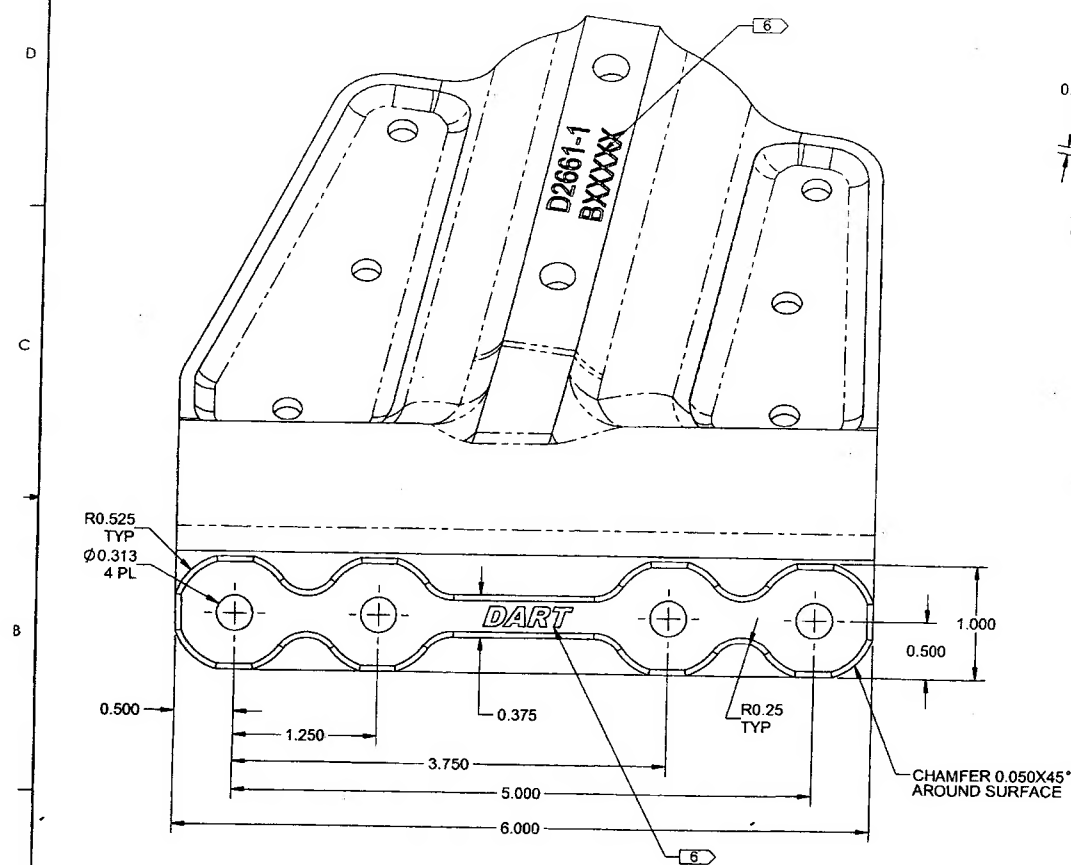
D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

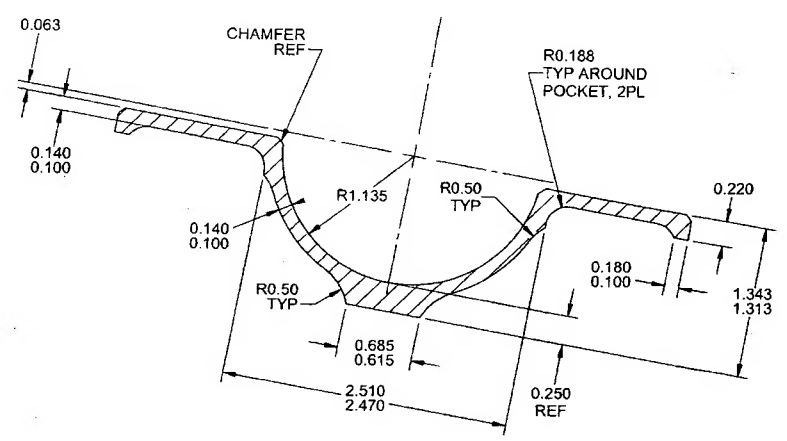
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2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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VIEW B-B
SCALE 1.5X
VIEW ROTATED



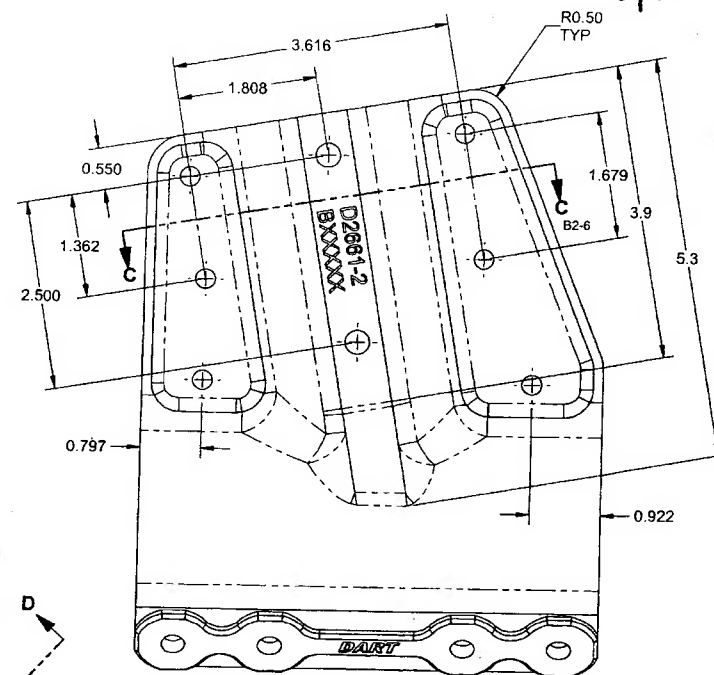
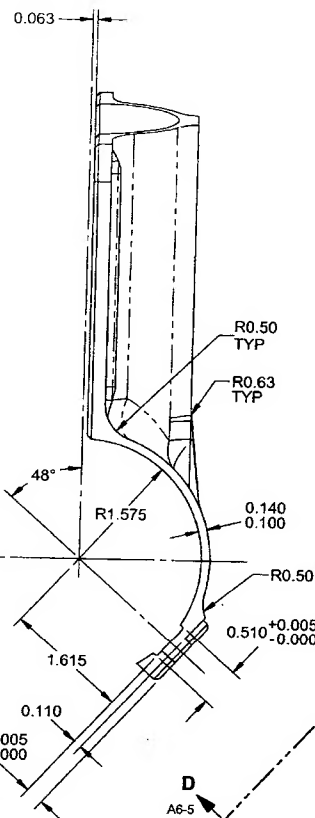
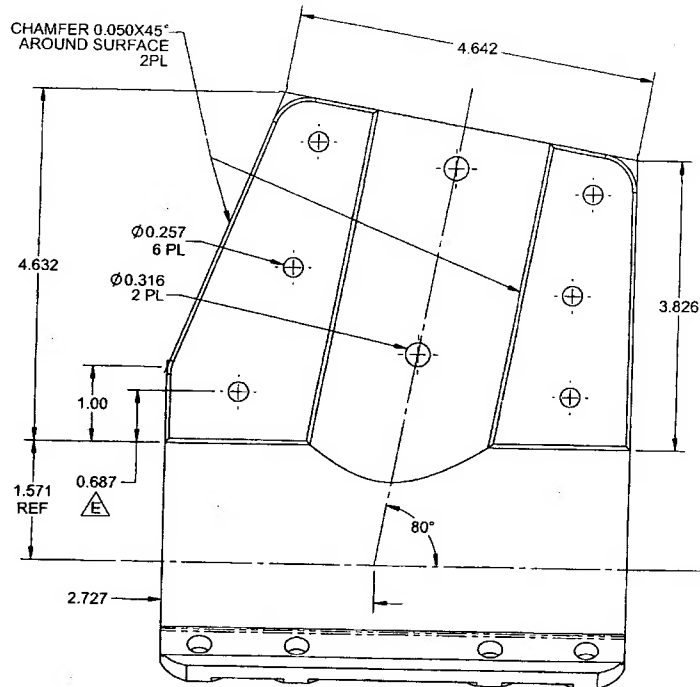
VIEW A-A
SCALE 1.5X

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MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.		DATE 11.10.31	NTS
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CHAMFER 0.050X45°
AROUND SURFACE
2PL



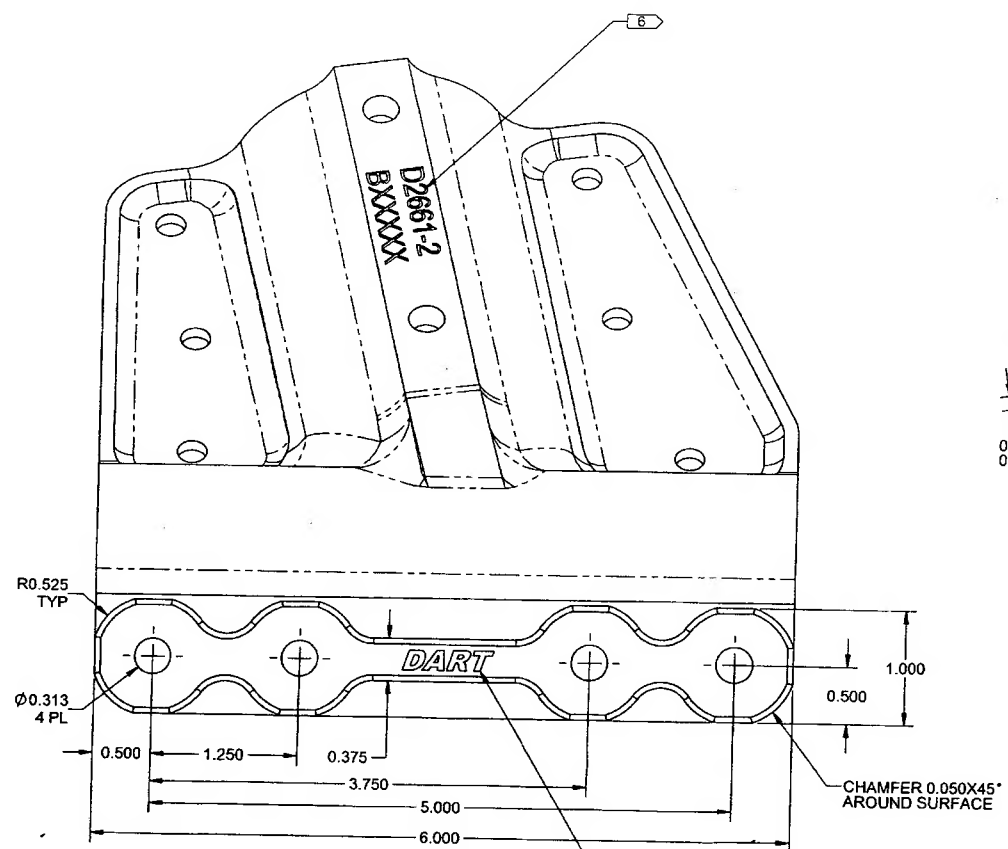
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2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

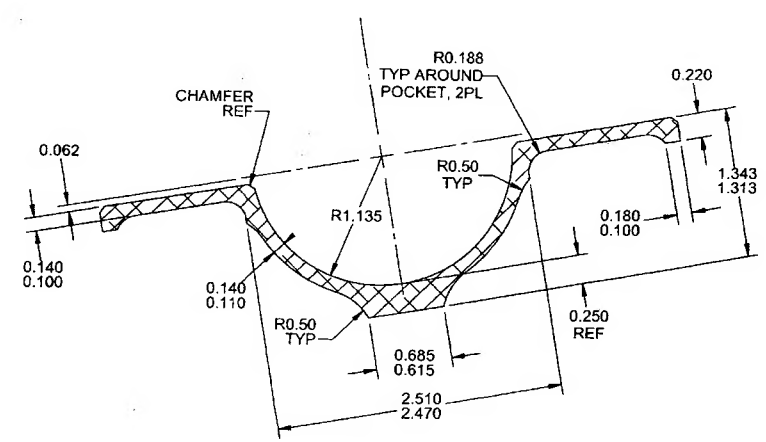
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
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91220



VIEW D-D 84-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

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2011-11-16

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DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	WAP	D2661	SHEET 5 OF 5
APPROVED	WAP	TITLE	SCALE
DE APPR.	WAP	SADDLE, OUTSIDE	NTS
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